

Date: Monday, 5/14/2007 7:12:29 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DART 13-MAN 3-POINT SHOULDER HARNESS KIT		
Job Number	: 32329 ~1		Part Number	: D412702041B		
Estimate Number	: 12865		Drawing Number	: D412702041B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 5/14/2007	S.O. No. : N/A	Drawing Revision	: D		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 5/15/2007		
Previous Run	:		Qty:	4 Um: Each		
Written By	:					
Checked & Approved By	:					
Comment	: est rev A 07.05.10 new issue EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D412-702-041B CHG001

KJ 07.05.16

2.0	D412702059	GROMMET KIT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

GROMMET KIT

batch: B 32327 ✓

3.0	D412702101B	Harness Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Harness Assembly

batch: B 32332 ✓

4.0	D412702103B	Harness Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Harness Assembly

batch: B 32333 ✓

5.0	D412702105B	Harness Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Harness Assembly

batch: B 32334 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Job Number: 32329		Part Number: D412702041B
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	D412702107B	HARNESS ASSEMBLY
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) HARNESS ASSEMBLY batch: B32335 ✓		
7.0	D412702109B	HARNESS ASSEMBLY
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) HARNESS ASSEMBLY batch: B32336 ✓		
8.0	D412702111B	HARNESS ASSEMBLY
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) HARNESS ASSEMBLY batch: B32337 ✓		
9.0	D412702113B	HARNESS ASSEMBLY
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) HARNESS ASSEMBLY batch: B32338 ✓		
10.0	D412702115B	HARNESS ASSEMBLY
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) HARNESS ASSEMBLY batch: B32339 ✓		
11.0	D412702117B	HARNESS ASSEMBLY
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) HARNESS ASSEMBLY batch: B32340 ✓		
12.0	D35421	BRACKET
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) BRACKET batch: B32129		7/14 SG

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT
Job Number: 32329		Part Number: D412702041B
Job Number:		
Seq. #:	Machine Or Operation:	Description :
13.0	D35711	GUIDE 
		
Comment: Qty.: 7.0000 Each(s)/Unit Total : 28.0000 Each(s) GUIDE batch: <u>131868</u> ✓		
14.0	D35713	GUIDE 
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) GUIDE batch: <u>131869</u> ✓		
15.0	D3572041	GUIDE ASSEMBLY 
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) GUIDE ASSEMBLY batch: <u>131870</u> ✓		
16.0	D3578041	DOUBLER 
		
Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s) DOUBLER batch: <u>131865</u> ✓		
17.0	D3610041	BRACKET 
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) BRACKET batch: <u>138240</u> ✓		
18.0	D36181	CAP 
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) CAP batch: <u>32426</u> ✓		
19.0	AN410A	Bolt 
		
Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s) Bolt batch: <u>1100291</u> ✓		<u>7/5/14</u> <u>59</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 5/14/2007 7:12:29 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 32329

Part Number: D412702041B

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 AN416A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch: M18949 ✓

21.0 AN425A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

BOLT

batch: M14095. ✓

Eyebolt

M13791 ✓

M101291 ✓

22.0 AN444A Eyebolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Eyebolt

batch: M19512 ✓

23.0 MS24693S274 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: M104214 ✓

24.0 MS24694S56 SCREW



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

SCREW

batch: M14195 X

25.0 MS24694S58 Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 40.0000 Each(s)

Screw

batch: M104407 X

26.0 MS24694S60 Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: M104407 X

7/14/07 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 5/14/2007 7:12:29 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 32329

Part Number: D412702041B

Job Number:



Seq. #:	Machine Or Operation:	Description :
27.0	AN960JD416	Washer
	Comment: Qty.: 26.0000 Each(s)/Unit Total : 104.0000 Each(s) Washer batch: M102929	X
28.0	AN960JD416L	Washer
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s) Washer batch: M103962	X
29.0	MS21042L4	Nut
	Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s) Nut batch: M103914	X
30.0	CR321244	Cherry Rivet
	Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s) Cherry Rivet batch: M166125	7/14/14 59
31.0	QC4	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	7/15/16 (2)
32.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-702-041B CHG001 Location: _____ PPP. Rev: DRAFT	7/15/16 (1) (2) Inspection Level 21 07/05/16

Job Completion



7/15/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
X					D412-702-041B	Dart 13-Man 3-Point Shoulder Harness Kit
	X				D412-702-043B	Dart 5-Man 3-Point Forward Facing Shoulder Harness Kit
		X			D412-702-045B	Dart 4-Man 3-Point Aft Facing Shoulder Harness Kit
			X		D412-702-047B	Dart 4-Man 3-Point Side Facing Shoulder Harness Kit
				X	D412-702-049B	Dart 1-Man 3-Point Forward Shoulder Harness Kit
1	1		1	1	D412-702-059	GROMMET KIT
2	1		1		D412-702-101B	HARNESS ASSEMBLY
1*	1*		1*		D3573-7	ADAPTER
1*	1*		1*		D3579-046	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1*	1*		1*		D3569-3	DECAL
2	1		1		D412-702-103B	HARNESS ASSEMBLY
1*	1*		1*		D3573-8	ADAPTER
1*	1*		1*		D3579-045	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1*	1*		1*		D3569-3	DECAL
1	1		1		D412-702-105B	HARNESS ASSEMBLY
1*	1*		1*		D3573-1	ADAPTER
1*	1*		1*		D3579-046	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S273	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1*	1*		1*		D3569-3	DECAL
1	1				D412-702-107B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-046	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT
1*	1*				D3569-3	DECAL
1	1				D412-702-109B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-045	SHOULDFR HARNESS

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WORK ORDER
NO. 32329

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT
1*	1*				D3569-3	DECAL
2		2			D412-702-111B	HARNESS ASSEMBLY
1*		1*			D3570-1	BRACKET
1*		1*			D3579-047	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1*		1*			D3569-3	DECAL
2		2			D412-702-113B	HARNESS ASSEMBLY
1*		1*			D3570-2	BRACKET
1*		1*			D3579-048	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1*		1*			D3569-3	DECAL
1			1		D412-702-115B	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-046	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
1*			1*		D3569-3	DECAL
1			1		D412-702-117B	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-045	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
1*			1*		D3569-3	DECAL
2	2				D3542-1	BRACKET
7	3		4	1	D3571-1	GUIDE
2	2				D3571-3	GUIDE
2		2			D3572-041	GUIDE ASSEMBLY
12	6		6	2	D3578-041	DOUBLER
2	2				D3610-041	BRACKET
2	2				D3618-1	CAP
4	4				AN4-10A	BOLT
2		2			AN4-16A	BOLT
4		4			AN4-25A	BOLT
2	2				AN4-44A	BOLT

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WORK ORDER
NO. 32329

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
2	2				MS24693S274	SCREW
3	3			1	MS24694S56	SCREW
10	2		8		MS24693S58	SCREW
1	1			1	MS24693S60	SCREW
26	6	20			AN960JD416	WASHER
4	4				AN960JD416L	WASHER
12	6	6			MS21042L4	NUT
24	12		12	4	CR3212-4-4	RIVET

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

25.29 Parts Lists for Dart Grommet Kits

QTY -059	QTY -069	Part Number	Description
X		D412-702-059	GROMMET KIT
	X	D412-702-069	GROMMET KIT
48		D3619-1	GROMMET
1		D3619-1T1	HOLE PUNCH
1		D3619-1T2	STRIKER BLOCK
1		D3619-1T3	PUNCH
1		D3619-1T4	DIE
24		D3619-2	GROMMET
1		D3619-2T1	HOLE PUNCH
1		D3619-2T2	STRIKER BLOCK
1		D3619-2T3	PUNCH
1		D3619-2T4	DIE

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